

Date: Friday, 7/4/2008 12:50:00 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLATE
Job Number : 40298	
Estimate Number : 12563	
P.O. Number :	Part Number : D323813
This Issue : 7/4/2008 S.O. No. :	Drawing Number : D3238 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 33513	Material :
Written By :	Due Date : 7/11/2008 Qty: 4 Um: Each
Checked & Approved By : <u>08 07 07</u>	
Comment : Est Rev:A New Issue 06-10-20 EC	
Est Rev:B Now on Waterjet 07-01-26 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S020	5052-H32 .020 Sheet
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Comment: Qty.: 0.0126 sf(s)/Unit Total : 0.0504 sf(s)

5052H32 aluminum sheet 0.020" thin

batch: 3019 ml 08 07 08

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3238

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

ml 08 07 08 (2)

ml 08 07 08 (2)

SB 08/07/08

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 08 07 08 (2)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/07/08 (4)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml / ml

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:50:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 40298

Part Number: D323813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(4x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PK 08-07-09

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(4x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 78

8/7/9

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

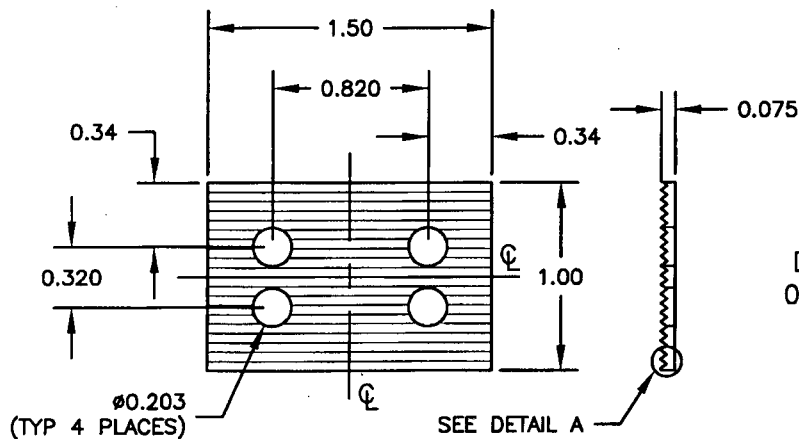
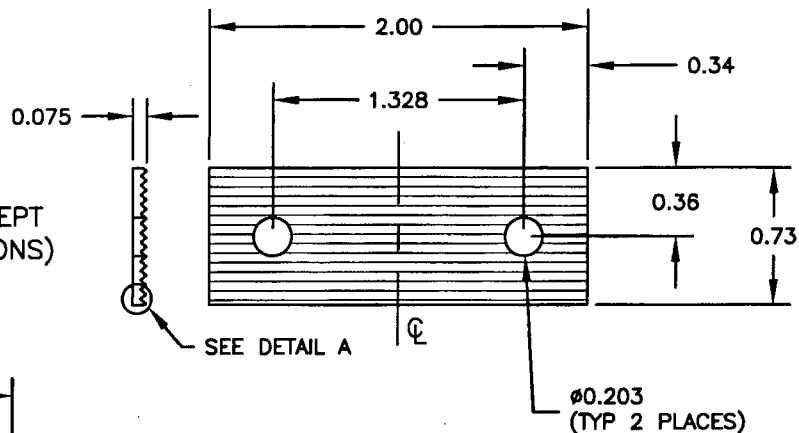
NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)**D3238-3 PLATE (SHOWN)**D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 403740298**NOTES:**

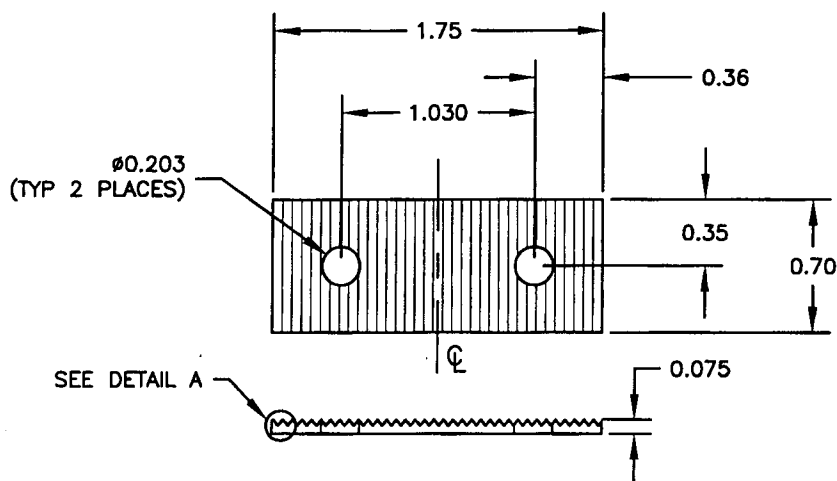
- MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.020)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- BREAK ALL SHARP EDGES 0.005 TO 0.010
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- SEE SHEET 3 FOR DETAIL A
- PARTS ARE SYMMETRIC ABOUT ϕ

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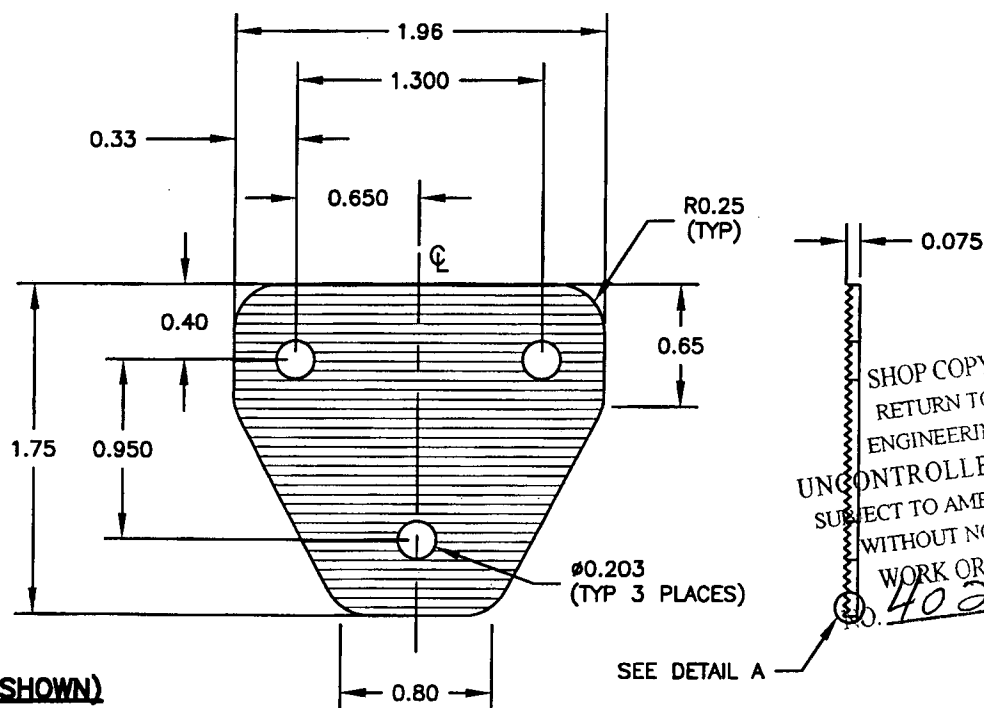


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1



RELEASED
07.02.20

D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

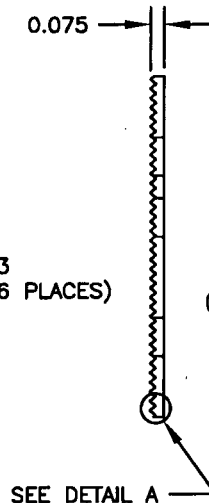
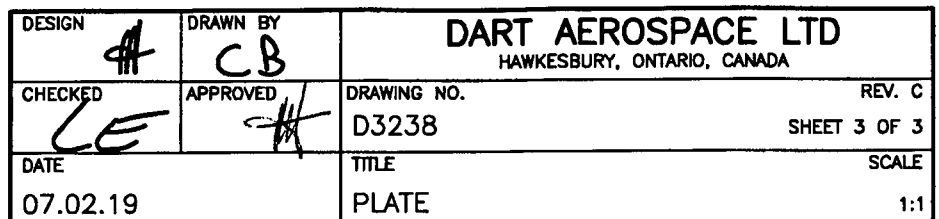


D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40298

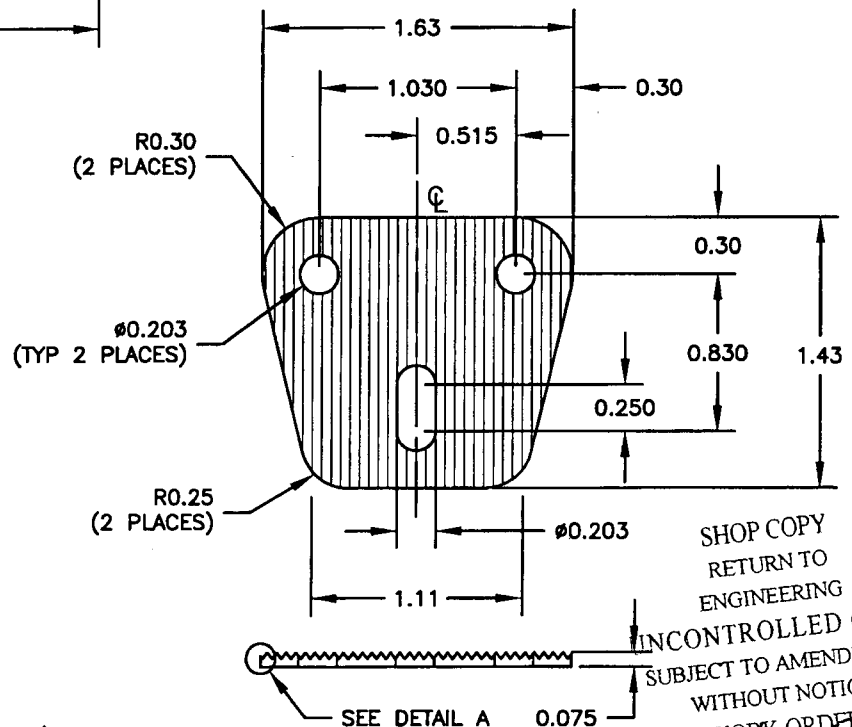
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07.02.20

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



DETAIL A
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1

3
SHOP COPY
RETURN TO
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WORK ORDER
NO. 40278

D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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